



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-636-016
Job Sheet 186338



Part No: D350-636-016

Job Qty: 1 ea

Part Name: Skidtube RH, Run-on Landing Wearplates, DART(Apical) Cylind./Aerazur Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/14/18

Job Tracking No:

Due Date: 11/30/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG D4168-042 REV.C IPP rev:A 10.09.28 new issue DD verf:EC IPP Rev:B 11.04.14 ecn11-553 DD verf:EC IPP Rev:C 11.10.18 as per NCR 11-906 DD verf:EC IPP REV:D 13.08.28 PER ECN13-594 DD VERF:JLM IPP REV:E 18.11.12 AS PER DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials



1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S129313



Part: D350-636-016

Job No: 186338

Serial No/Batch: S129313

Revision: C

Inspector:

Exp Date:

Instructions: TC STC SH99-7 Issue 2, FAA STC SR00646SE 15/10/28, EASA STC

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/30/18	0.00	0.00	Start Up Skidtubes-1		BE
110	Skidtubes	1 pcs		11/30/18	0.00	4.78	Skidtubes-1		BE
120	QC	1 pcs		11/30/18	0.00	0.00	QC10		38 DAS
130	QC	1 pcs		11/30/18	0.00	0.00	QC5		9-89 38
140	HandFinish	1 pcs		11/30/18	0.00	0.98	HandFinish1		DR 18/11/21
150	QC	1 pcs		11/30/18	0.00	0.00	QC7-2		DR 18/11/21
160	Skidtubes	1 pcs		11/30/18	0.00	4.78	Skidtubes-1		DR 18/11/21
170	QC	1 pcs		11/30/18	0.00	0.00	QC10		38 DAS
180	QC	1 pcs		11/30/18	0.00	0.00	QC5		9-89 38
190	HandFinish	1 pcs		11/30/18	0.00	0.98	HandFinish2		DR 18/12/12
200	SprayPaint	1 pcs		11/30/18	0.00	0.61	Spray Paint		DR 18/12/12
205	Outsource	1 pcs		11/30/18			ATE003-VC	DEC 17 2018	DR 18-12-12
210	QC	1 pcs		11/30/18	0.00	0.00	QC14		DR 18-12-12
230	HandFinish	1 pcs		11/30/18	0.00	0.98	HandFinish4		DR 18-12-12
240	QC	1 pcs		11/30/18	0.00	0.00	QC5		JAN 14 2019
250	Packaging	1 pcs		11/30/18	0.00	0.00	Packaging1-3	JAN 13 2019	9-89
260	QC	1 pcs		11/30/18	0.00	0.00	QC4	JAN 15 2019	46-89
270	Packaging	1 pcs		11/30/18	0.00	0.00	Packaging3-1	JAN 15 2019	9-89
275	DC	1 pcs		11/30/18	0.00	0.00	DC	JAN 15 2019	9-89
280	QC21-FG	1 Ea		11/30/18	0.00	0.00	QC21	JAN 15 2019	9-89

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg
 Descriptions: D4168-2 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D4168 sheet 5 (D4168-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K) 4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting, section R-R and open to 0.500" 5- Drill tow ring hole using DT9616 detail "J" 6- Drill most FWD wearplate hole using DT9678 locating of 66.54" hole 7- Open up holes of Detail J to 0.297" (total of 2 holes per side) +.201" (total of one hole per side) as per dwg D4168. 8- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: AK 1386B

9- Grind welds flush as per Dwg D4168

160 - 1-Open up holes using hole saw of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D4168. 2-Open up holes using hole saw of Detail K to 0.750" (total of 4 holes per side) as per dwg D4168. 3- Open float hole to 0.500" using uni-bit (4 per side) and Run on wearplate holes to .375" 4 per side 4-Chamfer holes of Detail K,L, ground handling and float holes per dwg D4168 (welding instructions on sheet 9) 5-Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: M1384 exp. date: 1/03/06 ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: 1386B 9- At section AP-AP drill out x-bolt spacer to 0.404" 10-Grind welds flush as per Dwg D4168 11-Spot face ground handling holes section (total of 4 places per side) as per dwg D4168 12- C'bore section CH-CH. ADJUST TOOLING AS REQUIRED. VERF BY: TF 13- Deburr holes, ensure tube is free of all scratches before sending to paint. ***** REF TO W/O BATCH: _____

180 - ***VERIFY C'BOARD IS GOOD***

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: P0042028 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5128306

210 - Inspect for foreign object per QSI 024

230 - 1- Install inserts as per Dwg D4168 2-Inspect for Foreign Objects 3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D4168 SIKA FLEX 241 BATCH: M128306 EXP DATE: 1/1/07 4- assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: M137692 5-Coat all exposed fasteners with "LPS Procyon" batch: M122690

250 - If making a D350-636-216 pick kit will only requires: 1 X AN3C37A 1 X AN3C34A 1 X AN3C42A 2 X D3493-1

260 - *****ensure antiseize is on AN8C21A bolts*****

270 - Identify and pack for shipping as per PPPD350-636-016 Location : FG071

275 - record fwd angle: 87.8 Photocopy blue file and type labels per PPP D350-636-016 CHG 006

M.U. 007088

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-RH	Extrusion Bent RH	1 Ea (1 ea)	90-Start up Operation	5109438
D2744	Cap	1 Ea (1 ea)	90-Start up Operation	5060499
D2739	350 I-Beam	1 Ea (1 ea)	160-Skidtubes	5126363
D2743	Crossbolt Spacer	8 Ea (8 ea)	160-Skidtubes	5133420
D3490-1	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	5082748
D3490-3	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	5107862
ALS4-1032-225	Rivnut	4 Ea (4 ea)	230-HandFinish	5058138
AN3C34A	Bolt	1 Ea (1 ea)	230-HandFinish	5134687
AN3C36A	Bolt	4 Ea (4 ea)	230-HandFinish	FM136658-1
AN3C6A	Bolt	4 Ea (4 ea)	230-HandFinish	5049457-1
AN6C44A	Bolt	4 Ea (4 ea)	230-HandFinish	5006333
AN8C35A	Bolt	1 Ea (1 ea)	230-HandFinish	5100398
D2745	Bushing	8 Ea (8 ea)	230-HandFinish	5128863
D3488-4	Blade Fitting, RH	1 Ea (1 ea)	230-HandFinish	5128529
D3492-1	Plug	8 Ea (8 ea)	230-HandFinish	5138108
D3492-3	Plug	8 Ea (8 ea)	230-HandFinish	5091848
D3631-1	Washer	8 Ea (8 ea)	230-HandFinish	5058407
D3873-1	Bushing	7 Ea (7 ea)	230-HandFinish	5129302
D4154-041	Wearplate Assembly	1 Ea (1 ea)	230-HandFinish	5142921
D4170-1	Bushing	4 Ea (4 ea)	230-HandFinish	5131023
D4171-1	Bushing	1 Ea (1 ea)	230-HandFinish	5061056
MS21043-3	Nut	5 Ea (5 ea)	230-HandFinish	5099569
MS21043-6	Nut	4 Ea (4 ea)	230-HandFinish	5093614
MS21083C8	Nut	1 Ea (1 ea)	230-HandFinish	5090633
NAS1149C0332R	Washer	4 Ea (4 ea)	230-HandFinish	5130139
NAS1149C0363R	Washer	9 Ea (9 ea)	230-HandFinish	5135100
NAS1149C0832R	Washer	1 Ea (1 ea)	230-HandFinish	5076017-2
NAS1515H3L	Washer	4 Ea (4 ea)	230-HandFinish	5083559
NAS1611-010	O-Ring	8 Ea (8 ea)	230-HandFinish	5106792
NAS1611-013	O-Ring	8 Ea (8 ea)	230-HandFinish	5106791
AN3C37A	Bolt	1 Ea (1 ea)	250-Packaging	5064011
AN3C42A	Bolt	1 Ea (1 ea)	250-Packaging	5108570
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging	5084120
D2741	Replacement Blade	1 Ea (1 ea)	250-Packaging	5129310
D3493-1	Washer	2 Ea (2 ea)	250-Packaging	5105813
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging	5104046
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging	5133789

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-3-BENT-RH	1	9	0
	D2744	1	27	0
160-Skidtubes	D2739	1	18	0
	D2743	8	47	0
	D3490-1	4	23	0
	D3490-3	4	62	0
230-HandFinish	ALS4-1032-225	4	1,358	0
	AN3C34A	1	20	0
	AN3C36A	4	500	0
	AN3C6A	4	181	0
	AN6C44A	4	107	0
	AN8C35A	1	35	0
	D2745	8	11	0
	D3488-4	1	0	0
	D3492-1	8	85	0
	D3492-3	8	87	0
	D3631-1	8	419	0
	D3873-1	7	10	0
	D4154-041	1	4	0
	D4170-1	4	10	0
	D4171-1	1	12	0
	MS21043-3	5	900	0
	MS21043-6	4	113	0
	MS21083C8	1	122	0
	NAS1149C0332R	4	3,157	0
	NAS1149C0363R	9	199	0
	NAS1149C0832R	1	369	0
	NAS1515H3L	4	409	0
	NAS1611-010	8	615	0
	NAS1611-013	8	241	0
250-Packaging	AN3C37A	1	87	0
	AN3C42A	1	42	0
	AN8C21A	2	79	0
	D2741	1	46	0
	D3493-1	2	51	0
	MS21083C8	2	122	0
	NAS1149D0863J	2	74	0

Part Specifications

Specifications could not be found.

Plex 11/14/18 11:40 AM dart.white.jesse

QTY -041	QTY -042	QTY -043	QTY -044	QTY -051	QTY -052	P/N	DESCRIPTION
X						D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X					D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X				D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X			D4168-044	350 SKIDTUBE ASSEMBLY, RH
				X		D4168-051	350 SKIDTUBE ASSEMBLY, LH
					X	D4168-052	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	1	1	D2739	WEB
8	8	8	8	8	8	D2743	CROSS BOLT SPACER
1	1	1	1	1	1	D2744	CAP
8	8	8	8	8	8	D2745	BUSHING
1		1		1		D3488-3	BLADE FITTING, LH
	1		1		1	D3488-4	BLADE FITTING, RH
4	4	4	4			D3490-1	CROSS BOLT SPACER
4	4					D3490-3	CROSS BOLT SPACER
		4	4			D3490-5	CROSS BOLT SPACER
8	8	8	8			D3492-041	PLUG ASSEMBLY
8	8					D3492-043	PLUG ASSEMBLY
		8	8			D3492-045	PLUG ASSEMBLY
8	8	8	8	8	8	D3631-1	WASHER
7	7	7	7	7	7	D3873-1	BUSHING
1	1	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1						D4168-1	SKIDTUBE WELDMENT, LH
	1					D4168-2	SKIDTUBE WELDMENT, RH
		1				D4168-3	SKIDTUBE WELDMENT, LH
			1			D4168-4	SKIDTUBE WELDMENT, RH
				1		D4168-5	SKIDTUBE WELDMENT, LH
					1	D4168-6	SKIDTUBE WELDMENT, RH
4	4	4	4	4	4	D4170-1	SPACER
1	1	1	1	1	1	D4171-1	BUSHING
4	4	4	4	4	4	ALS4-1032-225	INSERT
1	1	1	1	1	1	AN3C34A	BOLT
4	4	4	4	4	4	AN3C36A	BOLT
4	4	4	4	4	4	AN3C6A	BOLT
4	4	4	4	4	4	AN6C44A	BOLT
1	1	1	1	1	1	AN8C35A	BOLT
5	5	5	5	5	5	MS21043-3	NUT
4	4	4	4	4	4	MS21043-6	NUT
1	1	1	1	1	1	MS21083C8	NUT
4	4	4	4	4	4	NAS1149C0332R	WASHER
9	9	9	9	9	9	NAS1149C0363R	WASHER
1	1	1	1	1	1	NAS1149C0832R	WASHER
4	4	4	4	4	4	NAS1515H3L	WASHER

NOTES:

- 1) MATERIAL: MAKE D4168-1/-2/-3/-4/-5/-6 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB. STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.3
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4168-041/-042/-043/-044 = 32.3 lbs
D4168-051/-052 = 31.9 lbs
- 8) WELD PER DART QSI 004
- 9) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 10) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
- 11) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

C	ADDED -051/-052 (ZN D5-1 SHEETS 4, 15-16); ADDED D4168-5/-6 (ZN B5-1, SHEETS 9, 10); D3488-3/-4 REPLACES D3488-041/-042 (ZN C5-1, D2-11, D2-12, D2-13, D2-14); ADDED NOTES 13, 14 (ZN C4-1); NAS1149C0363R WAS AN960C10 (ZN A5-1, C8-11, C7-11, D8-11, C8-12, C7-12, D8-12, C8-13, C7-13, D8-13, C8-14, C7-14, D8-14); NAS1149C0332R WAS AN960C10L (ZN B1-11, B1-12, B1-13, B1-14); NAS1149C0832R WAS AN960C816L (ZN C1-11, C1-12, C1-13, C1-14)	ZF	18.03.01
B	ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1/-4/-5/-6/-7); UPDATED FINISH OPTIONS. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
A	NEW ISSUE	SC	10.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	DD	D4168	SHEET 1 OF 18
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.01	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED

2018 OCT 19
20 19-830

APPROVED

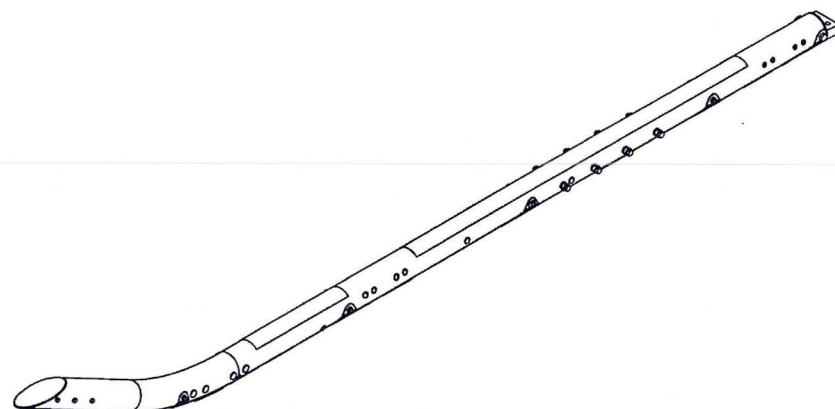
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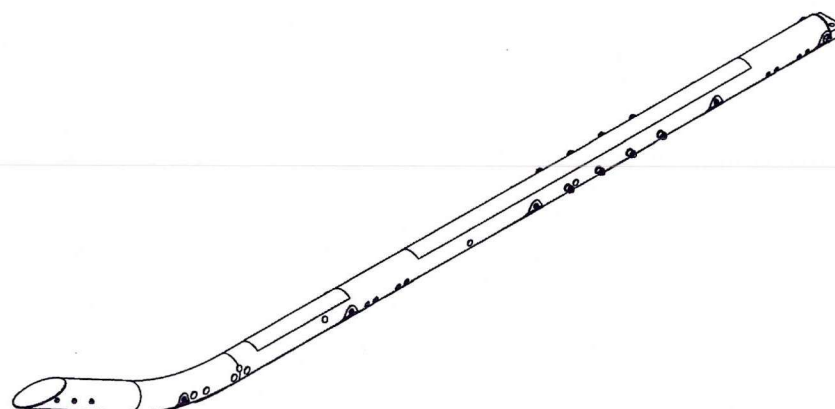
C

B

A



D4168-041 350 SKIDTUBE ASSEMBLY, LH



D4168-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2018 OCT 19 *qp*

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DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	DD	D4168	SHEET 2 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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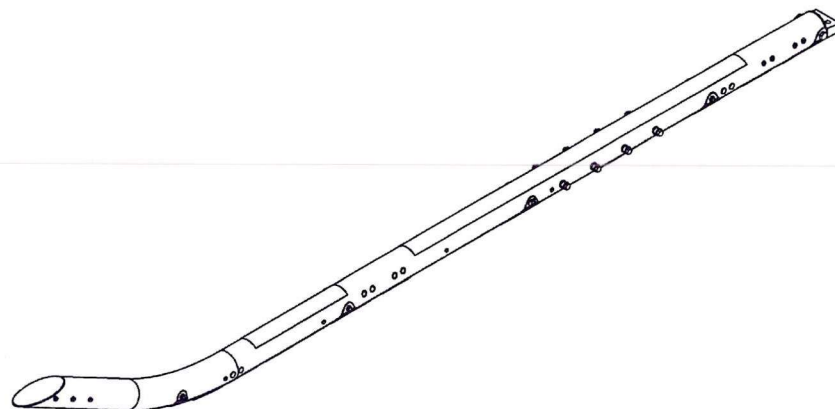
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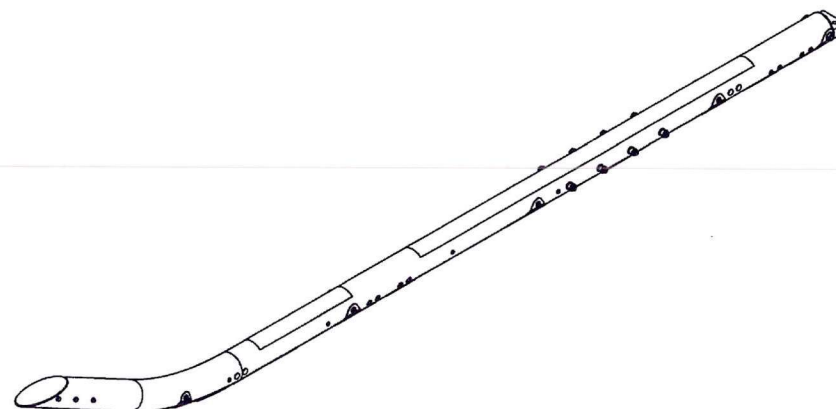
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D4168-043 350 SKIDTUBE ASSEMBLY, LH



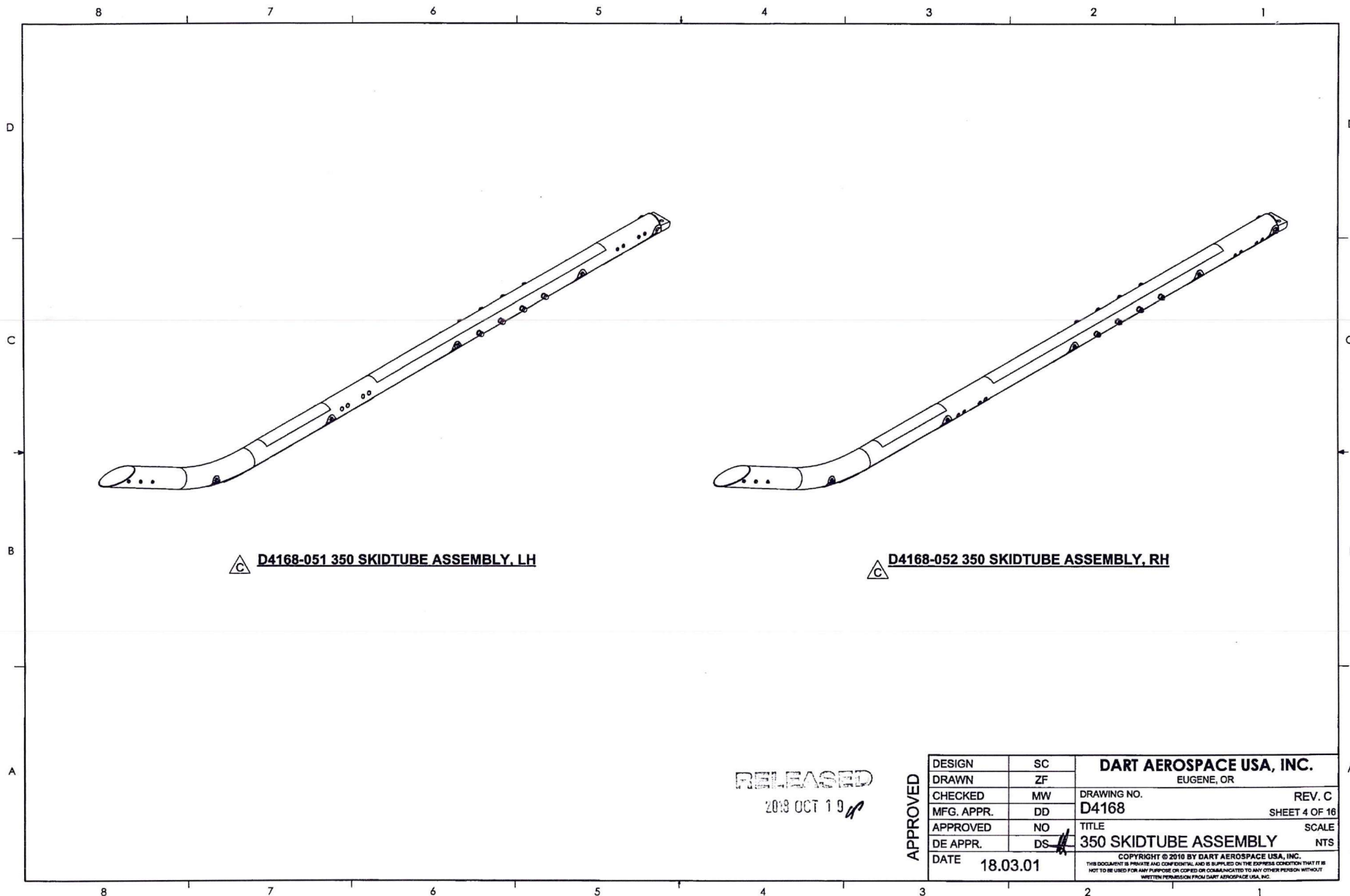
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2018 OCT 19

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CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	DD	D4168	SHEET 3 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1



D4168-051 350 SKIDTUBE ASSEMBLY, LH

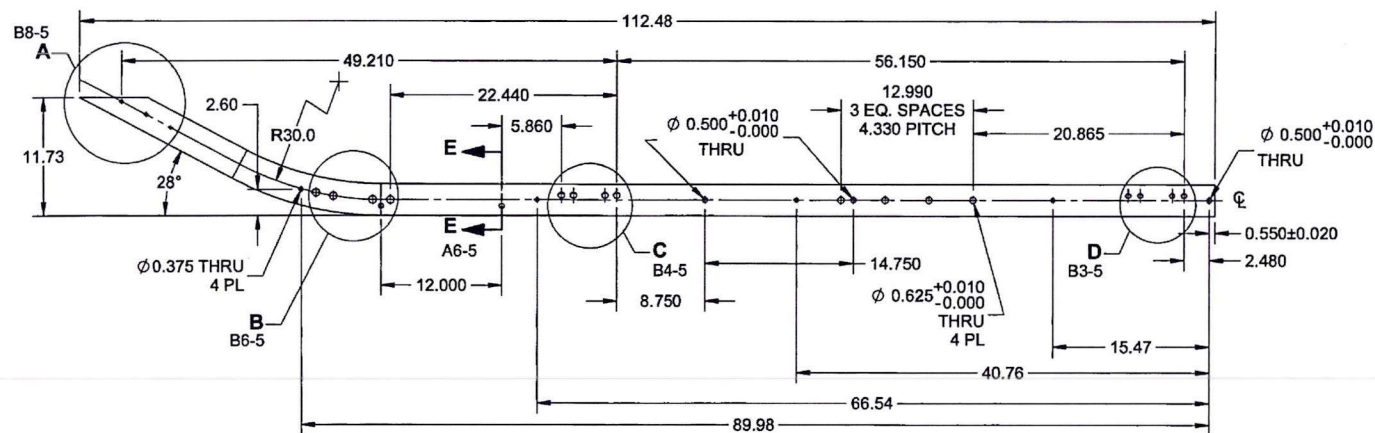
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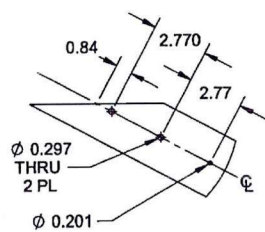
2019 OCT 19

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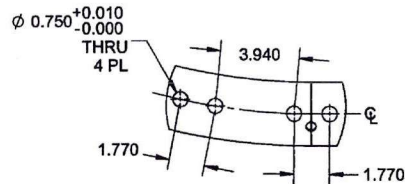
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CHECKED	MW	DRAWING NO.	REV. C
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APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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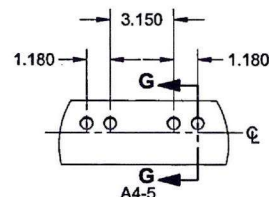
D4168-1 LH SKIDTUBE



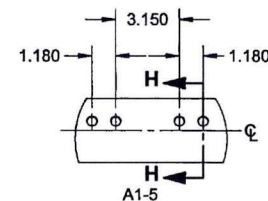
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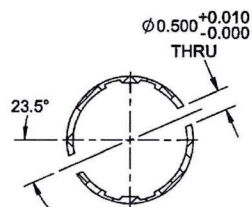
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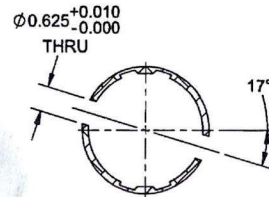
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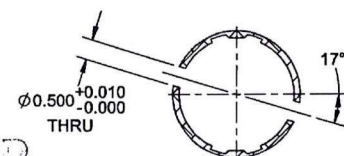
DETAIL D
SCALE 2X



SECTION E-E
SCALE 4X, 2 PL



SECTION G-G
SCALE 4X, 4 PL

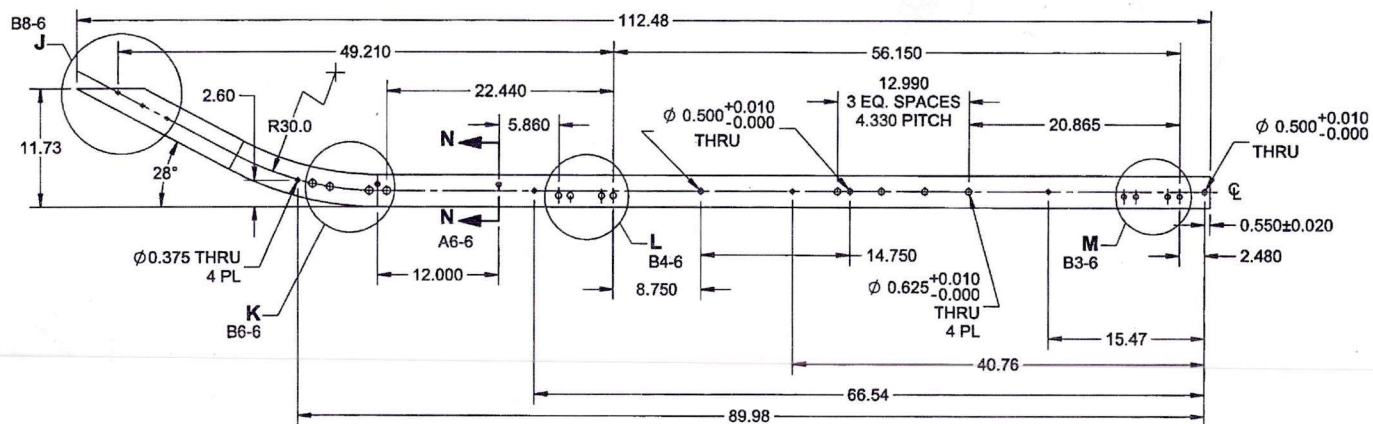


SECTION H-H
SCALE 4X, 4 PL

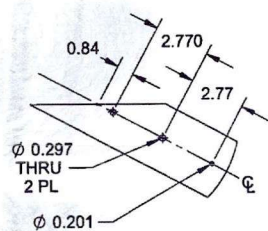
RELEASED
2010 OCT 19

APPROVED

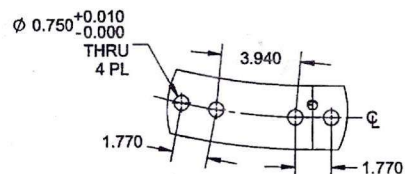
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	DD	D4168	SHEET 5 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.01	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



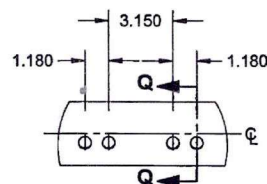
D4168-2 RH SKIDTUBE



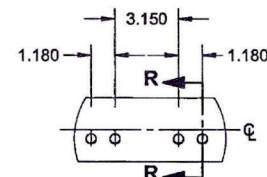
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SCALE 2X



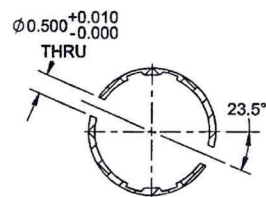
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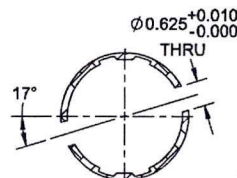
DETAIL L
SCALE 2X



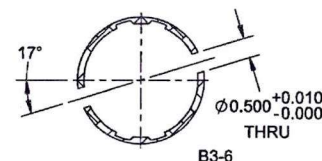
DETAIL M
SCALE 2X



SECTION N-N
SCALE 4X, 2 PL



SECTION Q-Q
SCALE 4X, 4 PL



SECTION R-R
SCALE 4X, 4 PL

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2018 OCT 19

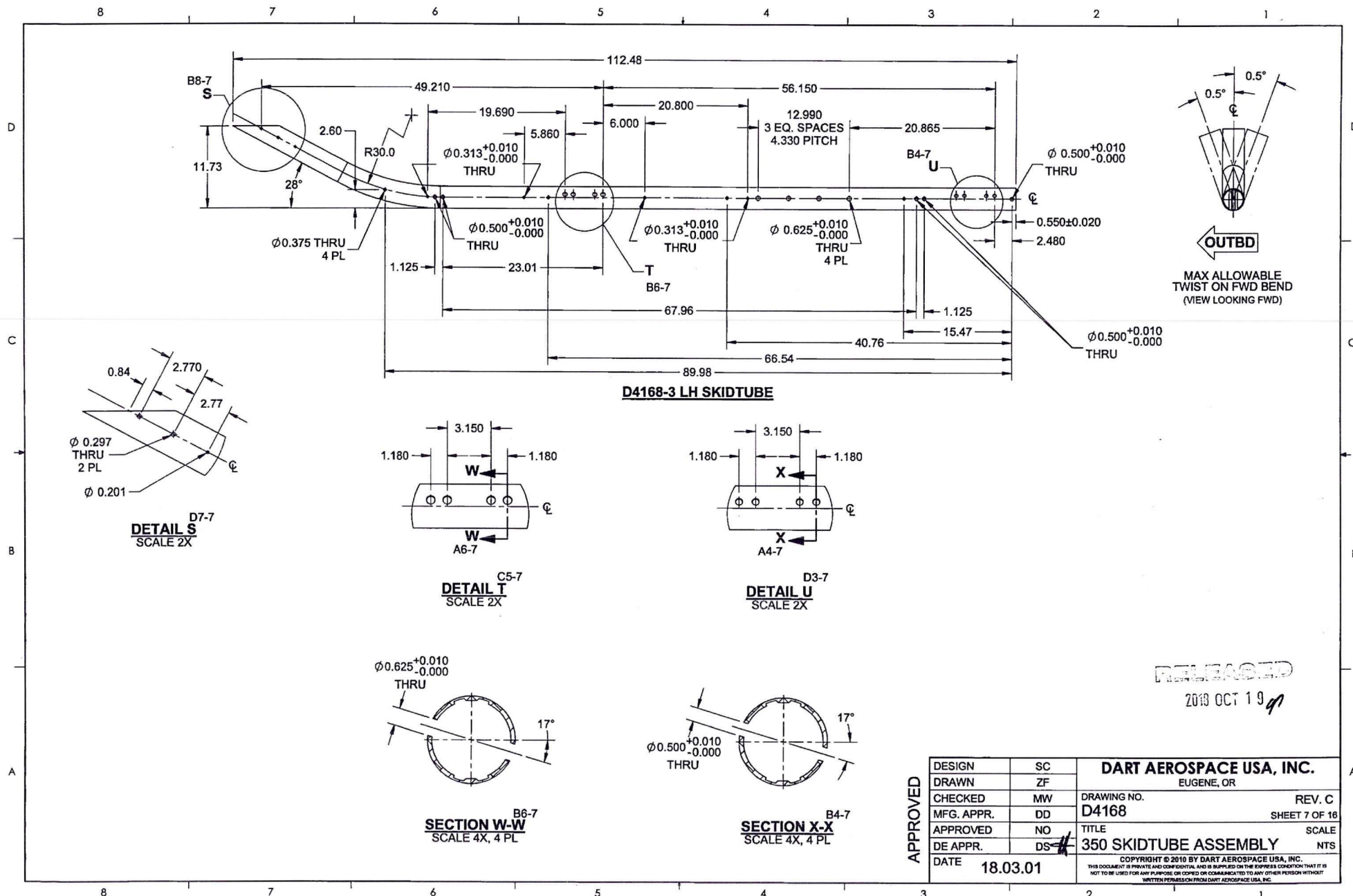
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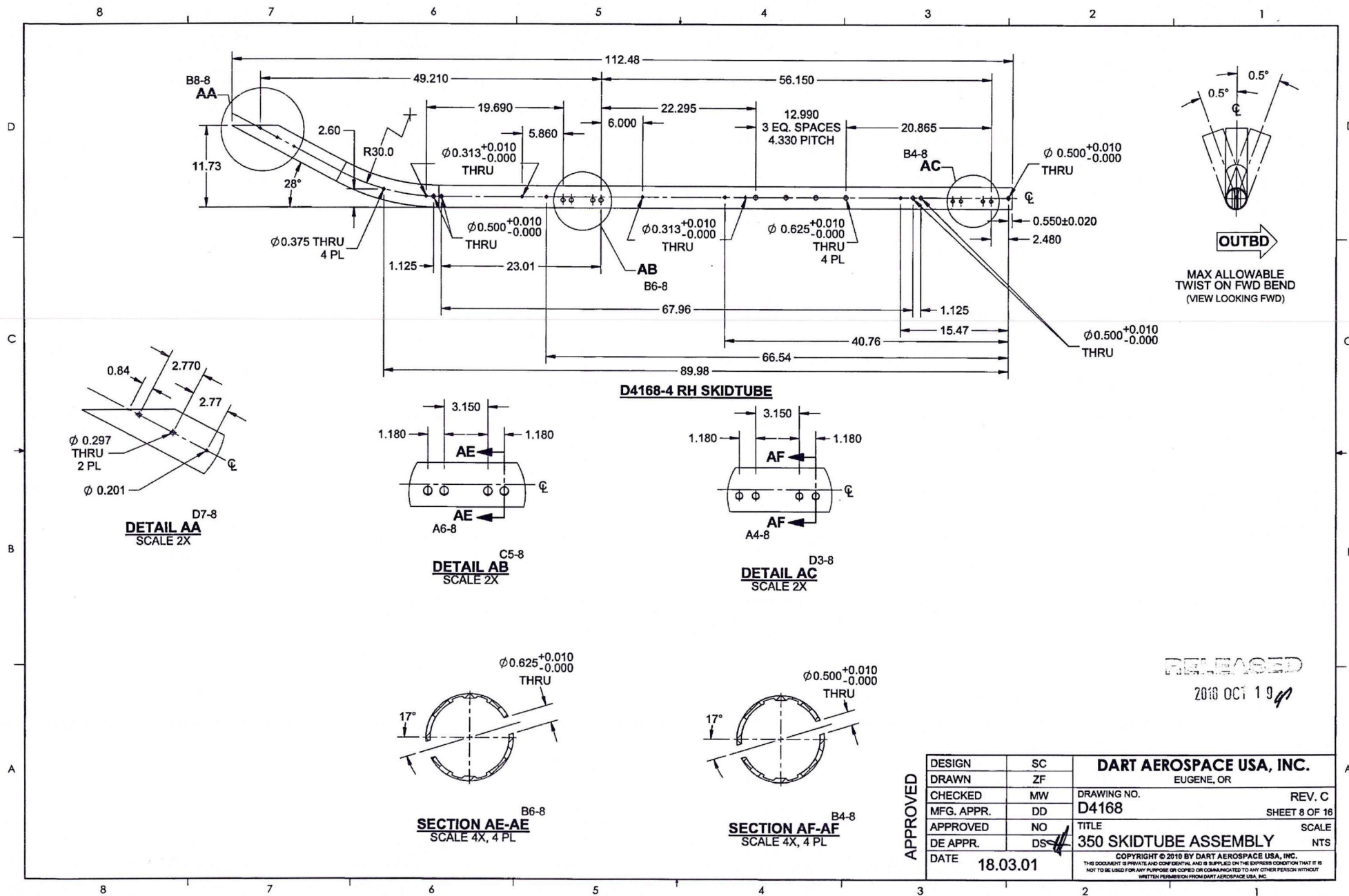
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DRAWN	ZF
CHECKED	MW
MFG. APPR.	DD
APPROVED	NO
DE APPR.	DS
DATE	18.03.01

DART AEROSPACE USA, INC.
EUGENE, OR

DRAWING NO. **D4168** REV. C
SHEET 6 OF 16
TITLE **350 SKIDTUBE ASSEMBLY** SCALE NTS

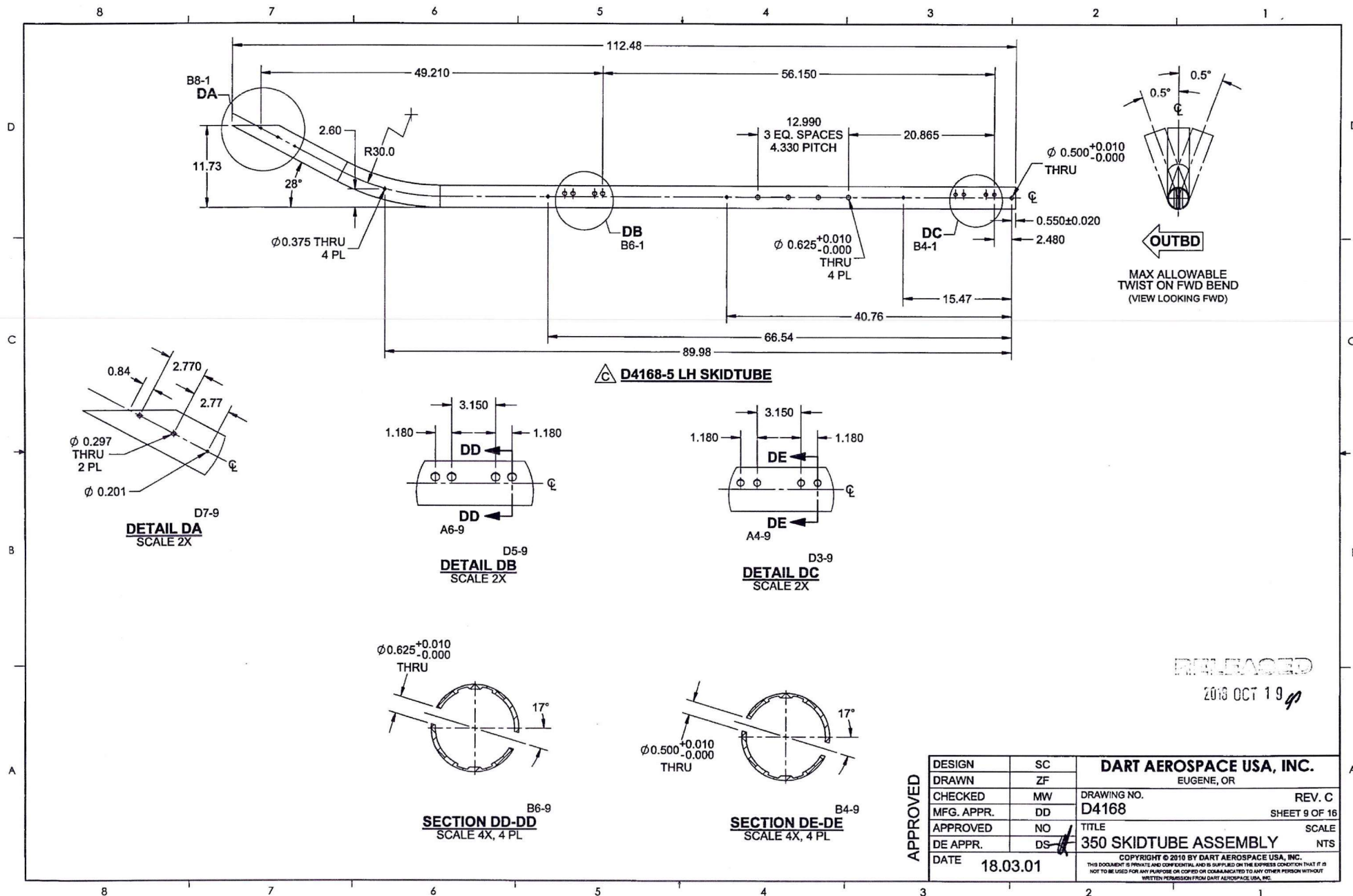
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2010 OCT 19

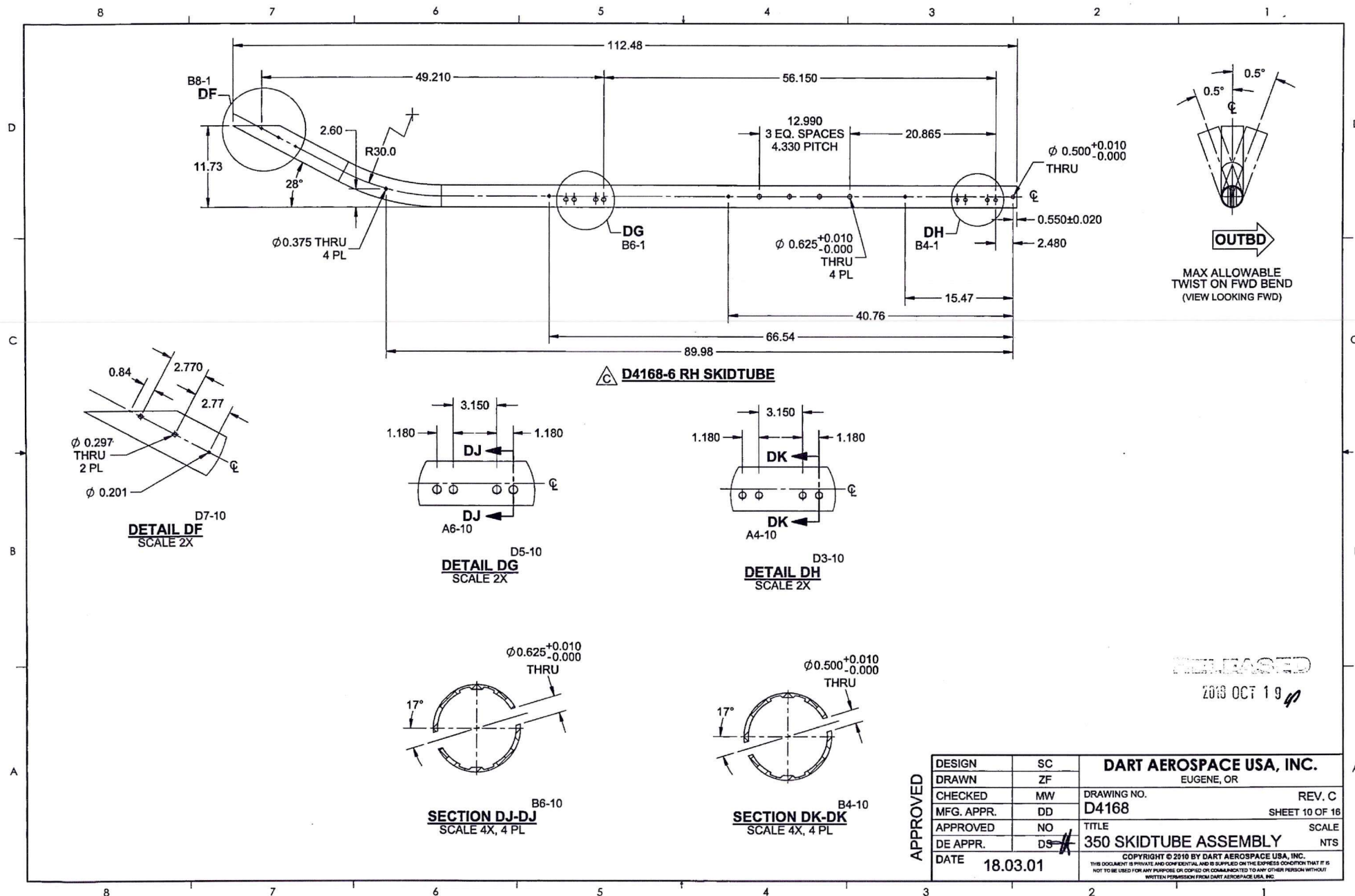
APPROVED	DESIGN	SC	DART AEROSPACE USA, INC.	
	DRAWN	ZF	EUGENE, OR	
	CHECKED	MW	DRAWING NO. D4168	REV. C
	MFG. APPR.	DD	SHEET 8 OF 16	
	APPROVED	NO	SCALE	
	DE APPR.	DS	350 SKIDTUBE ASSEMBLY NTS	
	DATE	18.03.01	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

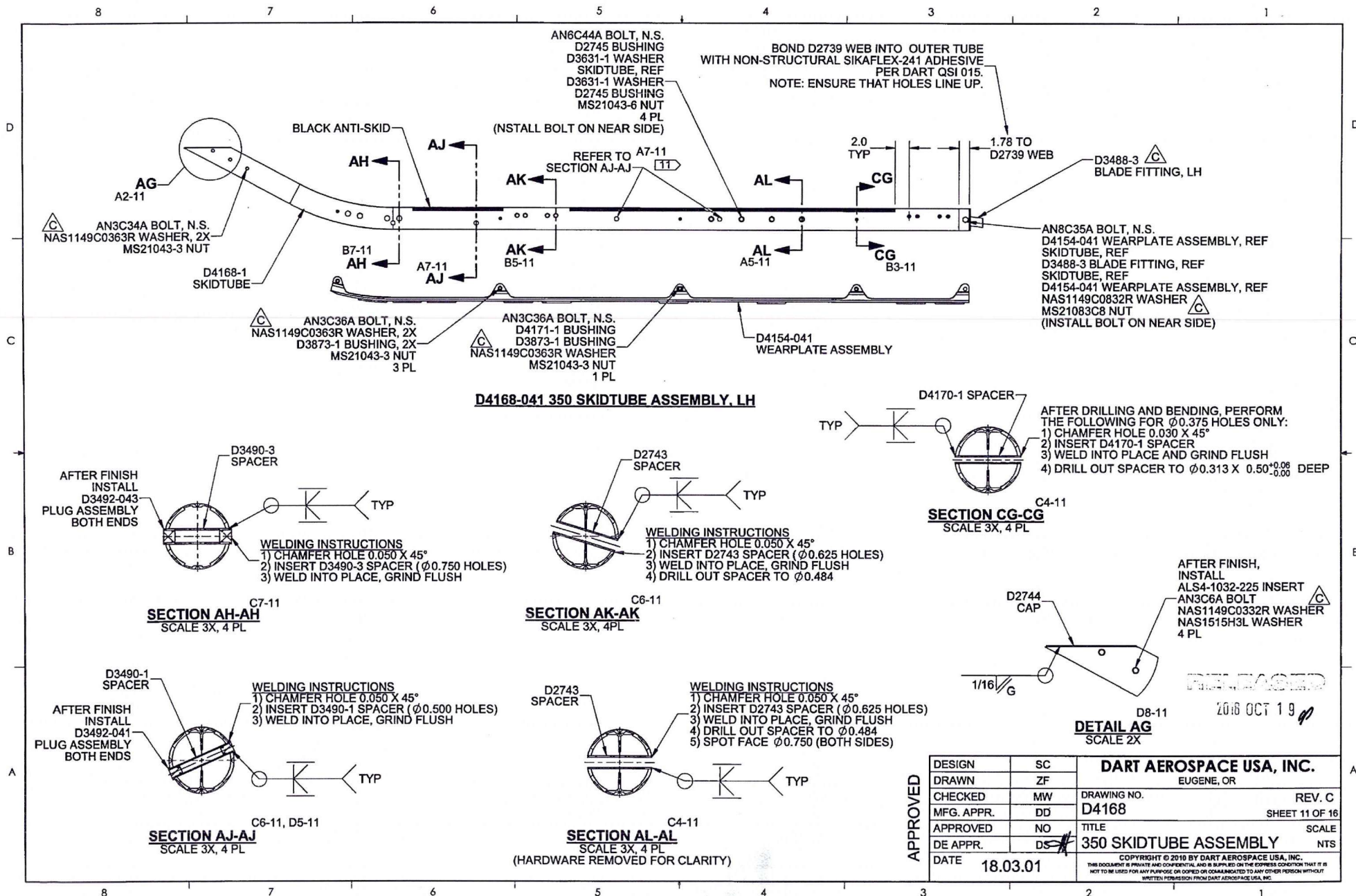


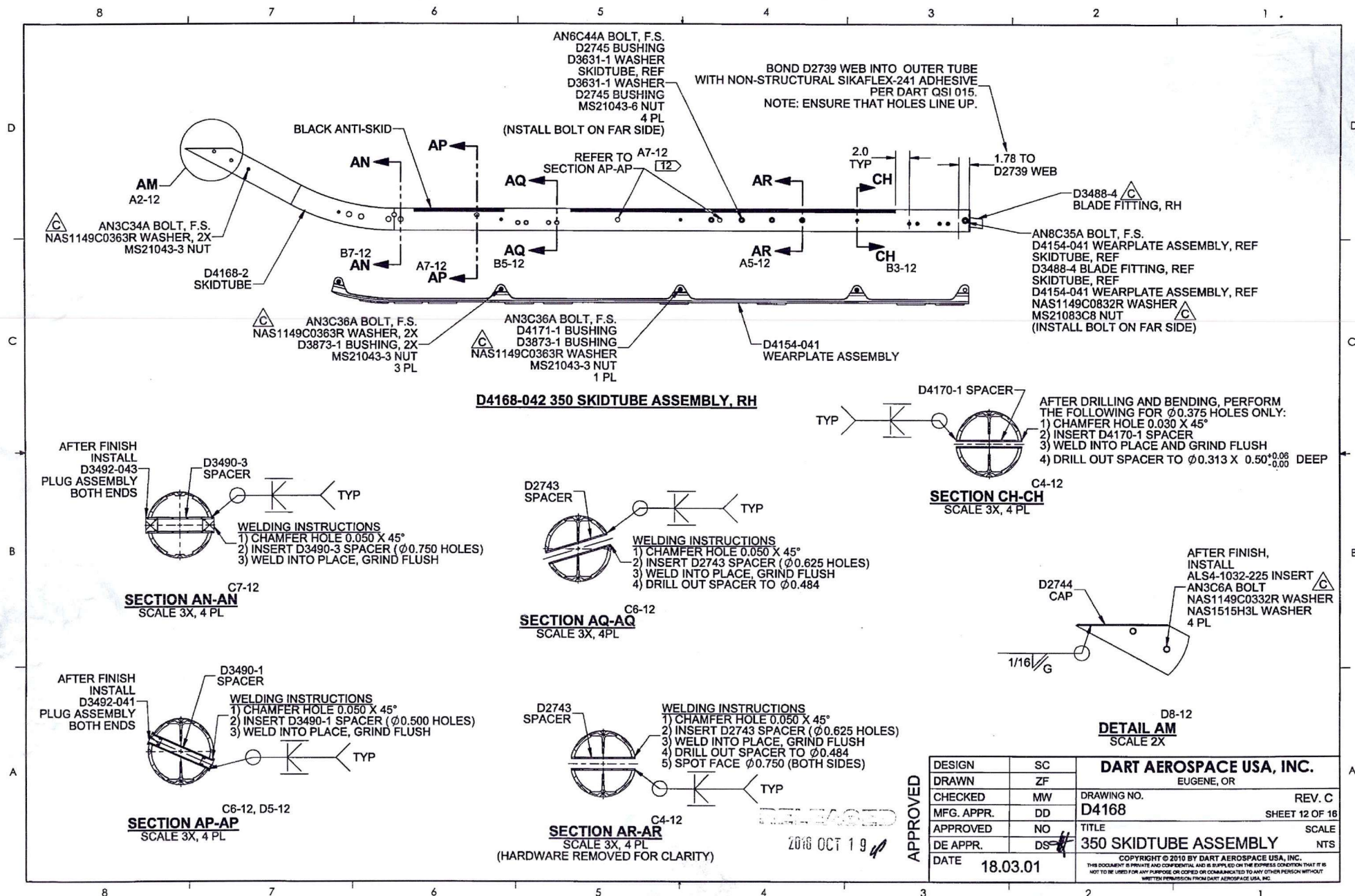
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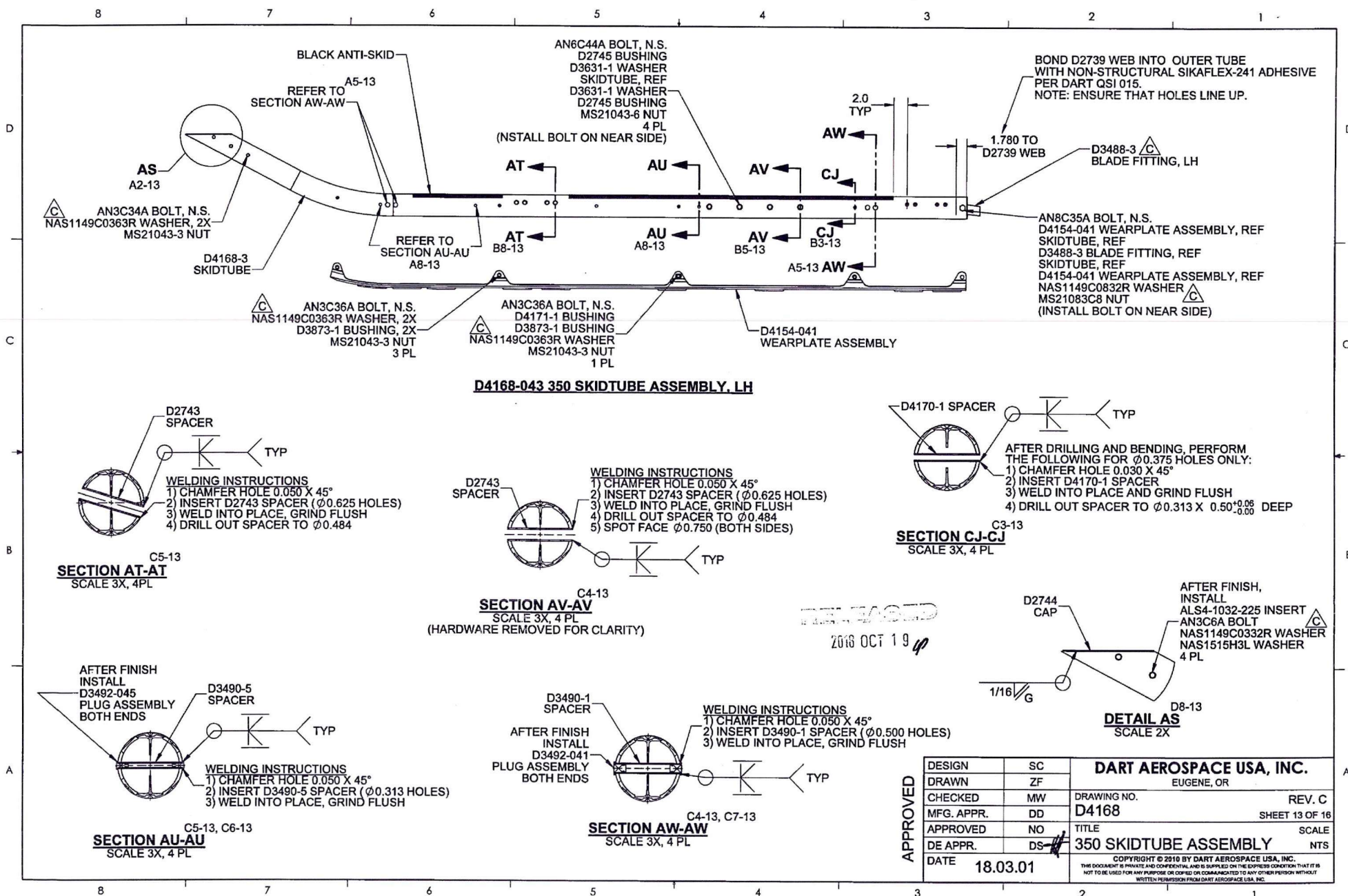
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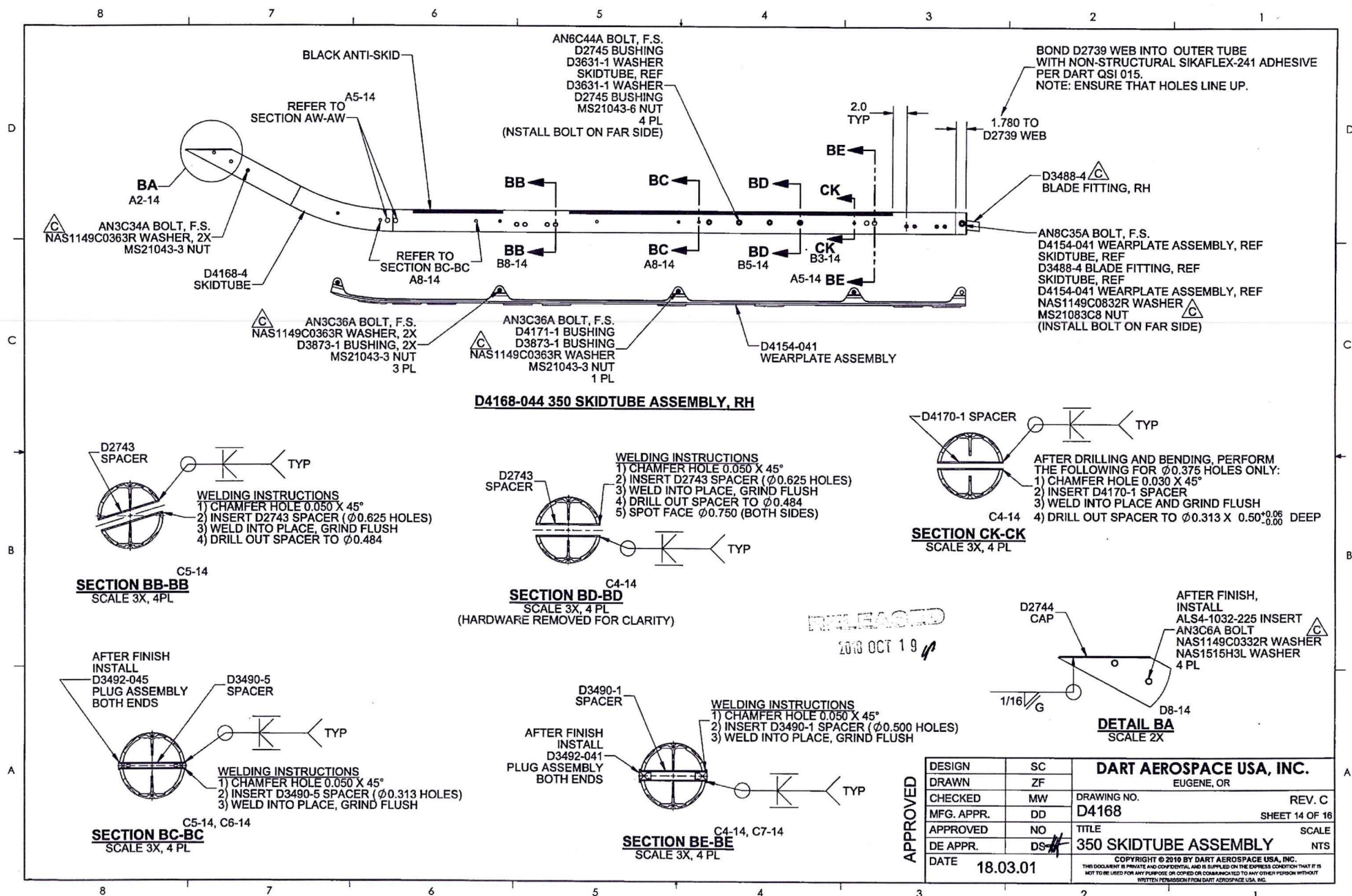
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	DD	D4168	SHEET 9 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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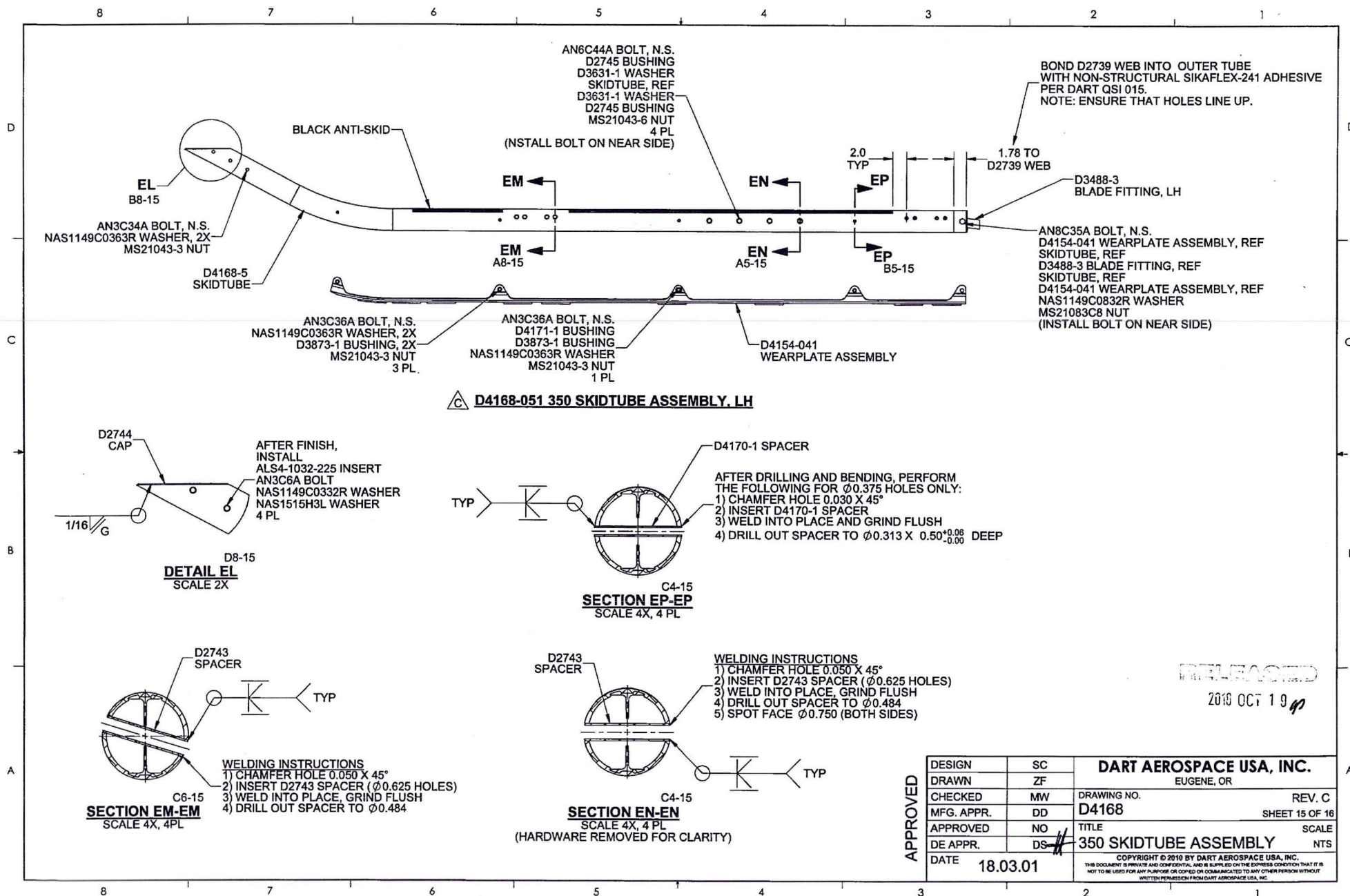


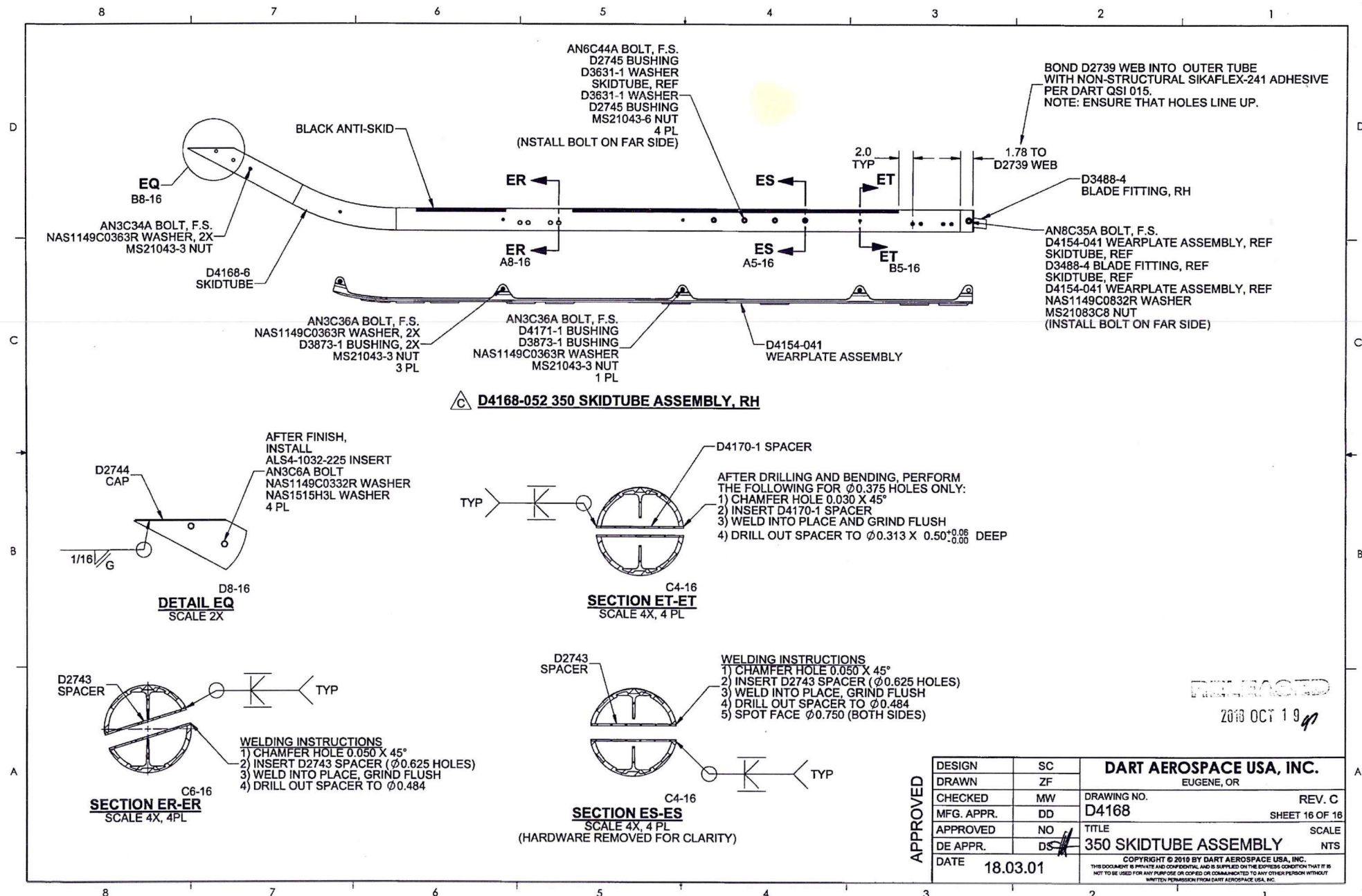














Dart Aerospace Ltd.
1270 Aberdeen St.
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO042028**

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO042028
PO Date: 12/12/18
Due Date: 12/18/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	177515	D350-636-011	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____	Firmed	-	12/18/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
2	186338	D350-636-016	AS350/355 - Skidtube - Float w/ Heavy-Duty Wearplates - RH : TC STC SH99-7 Issue 2, FAA STC SR00646SE 15/10/28, EASA STC EASA.10033942 11/02/21, BRAZIL 2009S05-01 09/05/08 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____	Firmed	-	12/18/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

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PURCHASE ORDER

PO042028

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	186804	D350-636-018	Skidtube RH, Run-on Landing, DART (Apical) Tri-Bag/Air Cruisers Float Comp. : TC STC SH99-7 Issue 2, FAA STC SR00646SE 15/10/28, EASA STC EASA.10033942 11/02/21, BRAZIL 2009S05-01 09/05/08 (Spray Paint / NDT Room), Spray Painting per QSI005 4.2 Issue P/O to Atelier Debosselage: _____ Spray Painting per QSI005 4.2 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____	Firmed	-	12/18/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
4	187142	D350-636-022	AS350/355 - Skidtube - Standard w/ Standard Wearplates - RH : TC STC SH99-7 Issue 2, FAA STC SR00646SE 15/10/28, EASA STC EASA.10033942 11/02/21, BRAZIL 2009S05-01 09/05/08 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____	Firmed	-	12/18/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
5	184463	D3391-025	Aft Tube Assembly : Various STC's PRIME AS PER DWG AND QSI005 4.2.1.3.3	Firmed	-	12/18/18	1 pcs	0 pcs	1 pcs	\$125.00/pcs	\$125.00



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
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PURCHASE ORDER

PO042028

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	186337	D350-636-015	AS350/355 - Skidtube - Float w/ Heavy-Duty Wearplates - LH : TC STC SH99-7 Issue 2, FAA STC SR00646SE 15/10/28, EASA STC EASA.10033942 11/02/21, BRAZIL 2009S05-01 09/05/08 1- PRIME AS PER DWG AND QSI 005 4.2.1.3.3 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____	Firmed	-	12/18/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
	185343		IX DEC 17 2018	Firmed	-	12/18/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
Sub Total:							2	0	2		\$450.00
7	187138	D350-636-021	AS350/355 - Skidtube - Standard w/ Standard Wearplates - LH : TC STC SH99-7 Issue 2, FAA STC SR00646SE 15/10/28, EASA STC EASA.10033942 11/02/21, BRAZIL 2009S05-01 09/05/08 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____	Firmed	-	12/18/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
	187135		IX DEC 17 2018	Firmed	-	12/18/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
	187137		IX DEC 17 2018	Firmed	-	12/18/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
Sub Total:							3	0	3		\$675.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042028

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	186803	D350-636-017	Skidtube LH, Run-on Landing, DART (Apical) Tri-Bag/Air Cruisers Float Comp. : TC STC SH99-7 Issue 2, FAA STC SR00646SE 15/10/28, EASA STC EASA.10033942 11/02/21, BRAZIL 2009S05-01 09/05/08 ISSUE P/O: _____ Spray Painting per QSI005 4.2 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____ C OF C IS REQUIRED	Firmed	-	12/18/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00

CX DEC 17 2018

Grand Total: \$2,375.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/12/18 9:49 AM dart.tsimiklis.chrisoula

7.0 PARTS LIST

D350-636-015/-016/-017/-018 SKIDTUBES AT CHG 006 AND SUBSEQUENT
D350-636-023/-024 SKIDTUBES AT CHG 001 AND SUBSEQUENT

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -023	Qty -024	Qty -047	Part Number	Description
	X							D350-636-015	SKIDTUBE INSTALLATION, LH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
		X						D350-636-016	SKIDTUBE INSTALLATION, RH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
			X					D350-636-017	SKIDTUBE INSTALLATION, LH AIRCUISE/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
				X				D350-636-018	SKIDTUBE INSTALLATION, RH AIRCUISE/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
					X			D350-636-023	SKIDTUBE INSTALLATION, LH, STD COMPATIBLE W/TRAINING WEARPLATE
						X		D350-636-024	SKIDTUBE INSTALLATION, RH, STD COMPATIBLE W/TRAINING WEARPLATE
							X	D350-636-047	TRAINING WEARPLATE KIT (LH/RH)
1	1							D4168-041	SKIDTUBE ASSEMBLY, LH
1		1						D4168-042	SKIDTUBE ASSEMBLY, RH
1			1					D4168-043	SKIDTUBE ASSEMBLY, LH
1				1				D4168-044	SKIDTUBE ASSEMBLY, RH
1					1			D4168-051	SKIDTUBE ASSEMBLY, LH
1						1		D4168-052	SKIDTUBE ASSEMBLY, RH
*1	1							D4168-1	SKIDTUBE WELDMENT, LH
*1		1						D4168-2	SKIDTUBE WELDMENT, RH
*1			1					D4168-3	SKIDTUBE WELDMENT, LH
*1				1				D4168-4	SKIDTUBE WELDMENT, RH
*1					1			D4168-5	SKIDTUBE WELDMENT, LH
*1						1		D4168-6	SKIDTUBE WELDMENT, RH
**2	8	8	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8	8	8		22541N120	NUT
*5	1	1	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1	1	1		NAS1149CO832R	WASHER
*7	1	1	1	1	1	1		MS21083C8	NUT
*8	1		1		1			D3488-3	BLADE FITTING, LH
*8		1		1		1		D3488-4	BLADE FITTING, RH
9	1	1	1	1	1	1		D2741	BLADE
10	2	2	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2	2	2		NAS1149CO863J	WASHER
12	2	2	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8	8	8		D2745	BUSHING
*16	4	4	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4	4	4		NAS1149CO332R	WASHER
*20B	4	4	4	4	4	4		NAS1515H3L	WASHER

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Revision: K

Date: 18.04.04